

Work Order ID 128623

128623

January-20-15 7:58:27 AM

Page 1

Item ID: D3041-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Clamp

Stop ***NS2***

Start Date: 1/20/15 Start Qty: 30.00

30

Cust Item ID:

Required Date: 2/06/15 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: MLS Date: 15-01-20

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3041	Rev C

100 0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D2423 Extrusion: 1.250" Long

110

110

HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine per folio FA153

DWG REV: _____

FOLIO REV: _____

120

120

QC2 Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

rec'd attached c/c to w/o

CL 15/01/2015 SO

C 50x 80 15-03-5

Outsource
Same P/p.

27263

Machine + powdercoat per QST

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Item ID: D3041-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp
 Start Date: 1/20/15 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 2/06/15 Req'd Qty: 30.00 ***30*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
160									
Powdercoat	Memo	0.00							
Powder Coating	Mask inside of 0.8120" diameter hole START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____								
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Small Fab	0.00							
180									
Small Fab	Memo	0.00							
Small Fab	1- Press D2611 bearing into lug as per Dwg D304 2- Stake bearing into place as per Dwg D3041								

CX 15/01/29

Done @ meter

N/A.

(50)

DAS
38

MAR 06 2015

50

FF

MAR 20 2015

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Page 4

January-20-15 7:58:27 AM

Item ID: D3041-1 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp
 Start Date: 1/20/15 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 2/06/15 Req'd Qty: 30.00 ***30*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-29
190									
QC	Memo	0.00							
Quality Control									APR 01 2015
200	Identify as per dwg & Stock Location: <u>150</u>	0.00							DAS 27 9-29
200									
Packaging	Memo	0.00							
Packaging									APR 07 2015
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									MLT 15-04-07

Handwritten signature/initials

Picklist Print

January-20-15 7:58:26 AM

Page 1

Work Order ID: 128623

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Parent Item: D3041-1

D3041-1

Parent Item Name: Clamp

Start Date: 1/20/15

Required Date: 2/06/15

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP RevA: as per revC1 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2423

Manufactured

No

180

f

0.0000

0.0833

D2423

Lug Extrusion

B:127892

**

30
CL 15/01/29

D2611

Manufactured

No

100

Each

48.0000

1

D2611

Bearing

**

3050
FF MAR 20 2015

Location

128963

Loc Qty

Loc Code

ST008A

130047

28

108514

8

124478

20

ST12a

20

127926

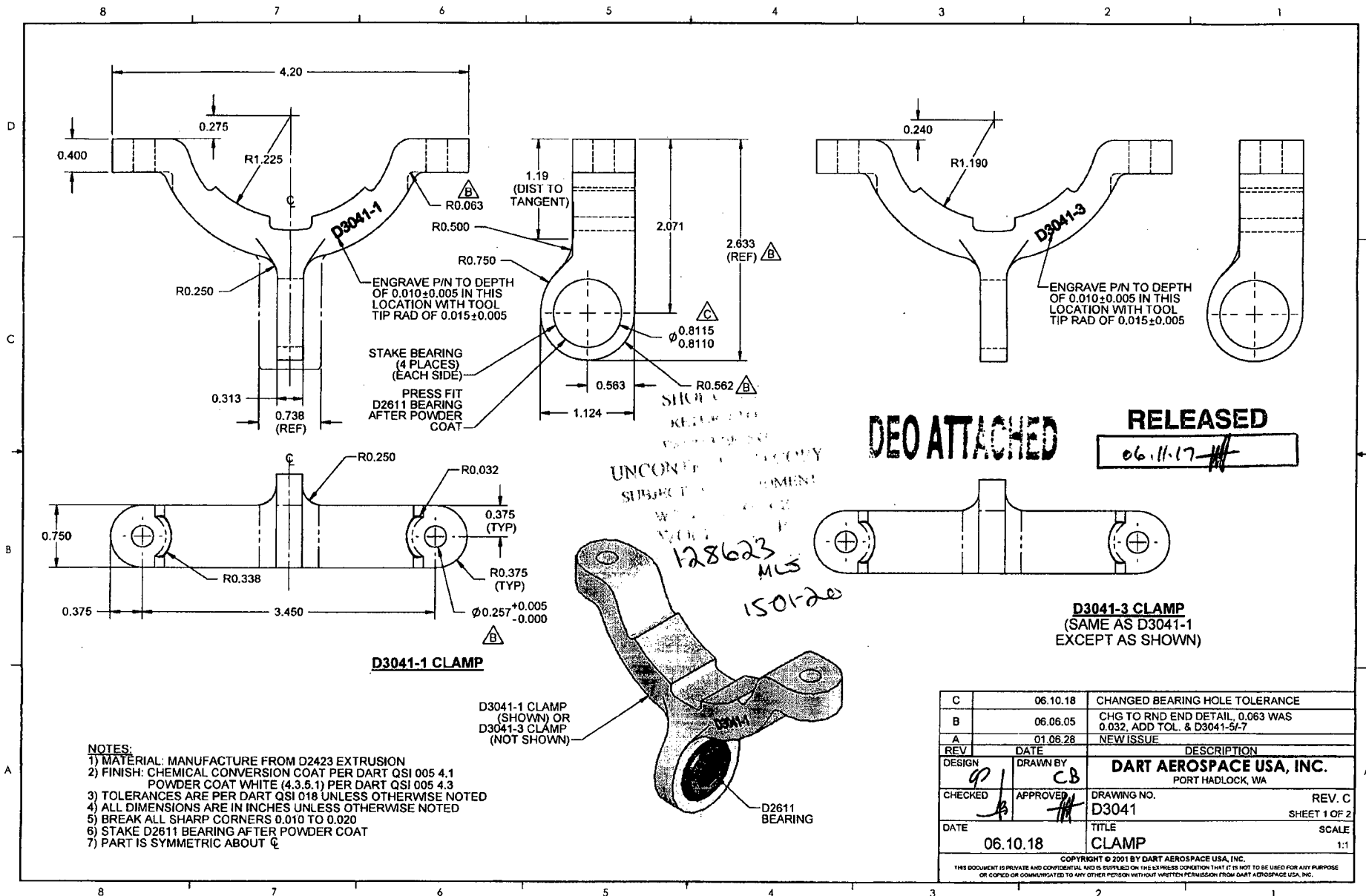
20

10
20
20

D3041-1P

X 80

50x SP15-03-5

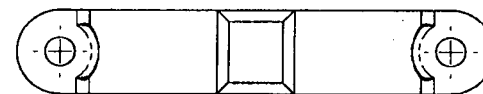
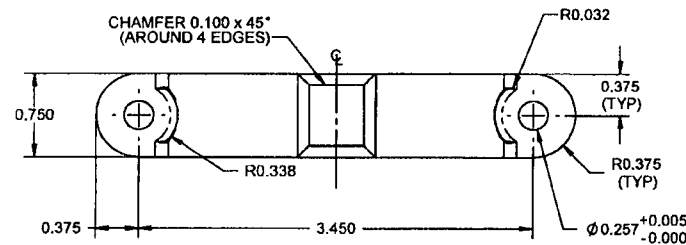
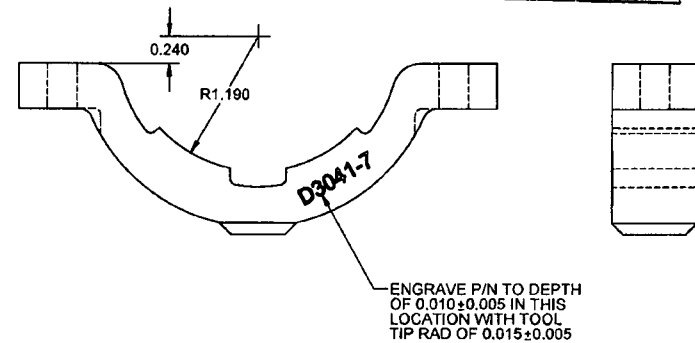
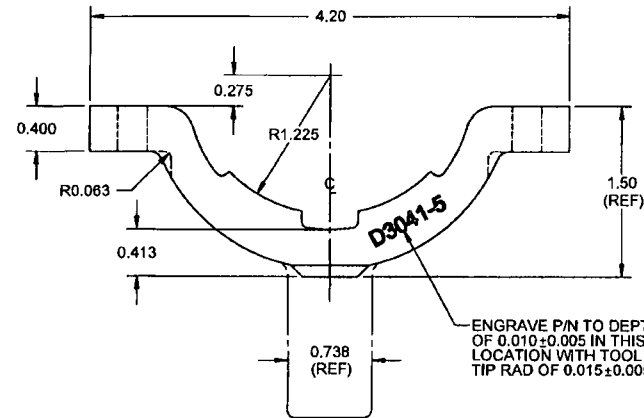


C	06.10.18	CHANGED BEARING HOLE TOLERANCE
B	06.06.05	CHG TO RND END DETAIL, 0.063 WAS 0.032, ADD TOL. & D3041-5/-7
A	01.06.28	NEW ISSUE
REV	DATE	DESCRIPTION
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3041
DATE	06.10.18	TITLE CLAMP
COPYRIGHT © 2001 BY DART AEROSPACE USA, INC.		REV. C
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		SCALE 1:1

DEO ATTACHE

RELEASED

06.11.17

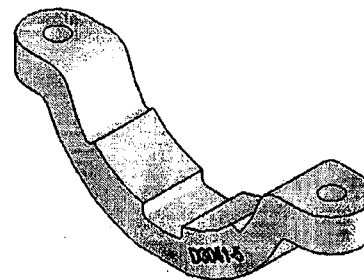


D3041-7 CLAMP
(SAME AS D3041-5
EXCEPT AS SHOWN) $\triangle$

D3041-5 CLAMP $\triangle$

NOTES:

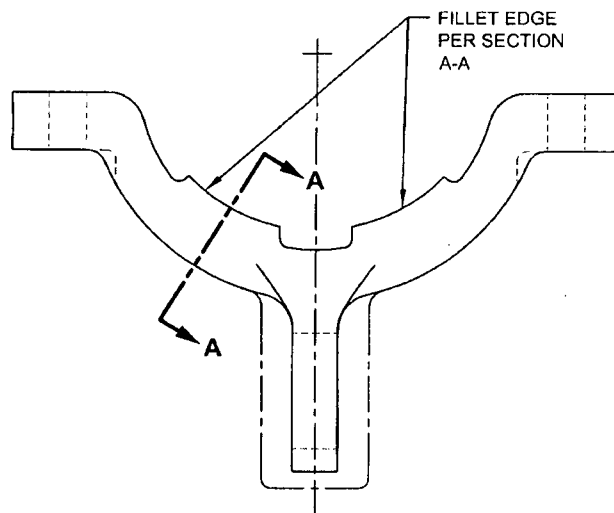
- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 6) PART IS SYMMETRIC ABOUT ϕ



DESIGN <i>JP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>JP</i>	APPROVED <i>JP</i>	DRAWING NO. D3041	REV. C SHEET 2 OF 2
DATE 06.10.18	TITLE CLAMP		SCALE 1:1
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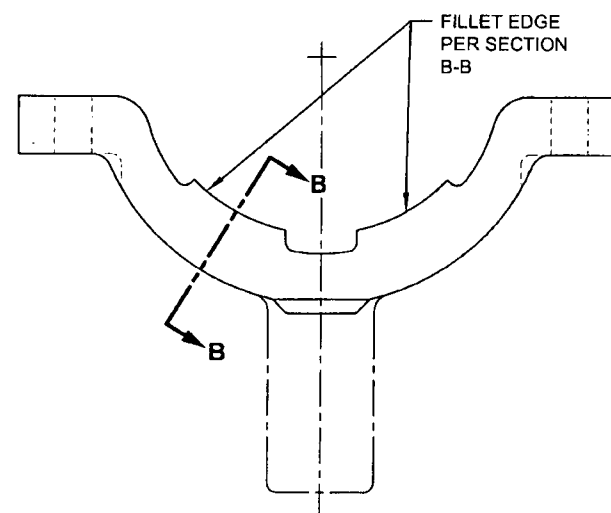
DRAWING NO. D3041	TITLE CLAMP	REV. C	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3041-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN ADS	CHECKED	MFG. APPR.	APPROVED	DE APPR.		
DATE 09.03.04	DATE 09.03.12	DATE 09.03.12	DATE 09.03.13	DATE 09.03.13		

ADD FILLETS TO -1/-3/-5/-7 PER SECTIONS A-A AND B-B TO PREVENT CHAFING OF RUBBER CUSHIONS AS SHOWN:



D3041-1 CLAMP

D3041-3 CLAMP



D3041-5 CLAMP

D3041-7 CLAMP



R0.060 MIN - R0.10 MAX
2PL

SECTION A-A

SCALE 2X

SECTION B-B

SCALE 2X

SEE PAR 122 FOR FURTHER DETAILS

RELEASED
09/07/07

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

OUTSTANDING PO REPRINT

Purchase Order ID PO27263

Purchase Order Date 1/29/2015

PO Print Date 3/5/2015

Page Number 1 of 1

Order From : VC-MET003
METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

Ship To : DART AEROSPACE LTD
1270
ABERD
EEN
HAWKE
SBURY,
ON
K6A
1K7
CANAD
A

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613 678 3957	Customer POID	
Vendor Fax	613 678 3956	Customer Tax #	10127-2607
Ship To Contact		Terms	Net 10
Ship To Phone		Currency	CAD
		FOB	Destination-Collect
Ship Method	Dart Truck		
Ship Acct			

Line Nbr	Item ID Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable	Req Qty	Extended Price
1	D3041-1P	Clamp	2/24/2015 Yes 2/24/2015	50.00 Each	\$700.00
AS PER DWG D3041 REV. C ALODINE & PAINT AS PER QSI005 B128623					

8815-03-5

Line Total: \$700.00

Outstanding PO Total: \$700.00

Change Nbr: 4

Change Date: 2/12/2015

Terms & Condition of
Purchasing(Suppliers) and
Procurement Quality Clauses are an
integral part of our AS9100



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 20332
Date: Mar 04, 2015
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 27263	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date: Mar 04, 2015

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3041-1 Clamp, as per drawing D3041 REV.C Alodine and paint as per QS1005 Date available February 24 2015	Each	50	50 ✓	
D3041-3 Clamp, as per drawing D3041 REV.C Alodine and paint as QS1005 Date available February 24 2015	Each	30		
D3041-5 Clamp, as per drawing D3041 REV.C Alodine and paint as per QS1005 Date available March 3 2015	Each	50		
D3041-7 Clamp, as per drawing D3041 REV.C Alodine and paint as per QS1005 Date available March 3 2015	Each	30		
D4091-1 Lug, as per drawing D4091 Rev.A Alodine and paint as per QS1005 Date available March 3 2015	Each	30		
D2230-3 Mounting Lug, as per drawing D2230 REV.G Alodine and paint as per QS1005 Date available February 24 2015	Each	80		
<u>3</u> Shipping boxes received ☒ Shipping boxes returned				
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by 		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
50 ✓	D3041-1	Lug	27263

PAINT BATCH # 11127

MATERIAL: supplied by DART B17892

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Jan Norris", is written over a horizontal line.

Jan Norris

Vankleek Hill, March 4 2015